

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016354**Date Inspected:** 10-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Mr. Qiu Wen		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No N/A
Weld Procedures Followed:	Yes	No N/A
Verified Joint Fit-up:	Yes	No N/A
Approved WPS:	Yes	No N/A
Delayed / Cancelled:	Yes	No N/A
Component:	Tower	

Bridge No: 34-0006**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay no. 11

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040610/041271 perform SMAW welding on; East shaft, Lift 5, intersection diaphragm plate to Skin E and the weld joint is identified as ESD1-TL5-2 BF-22/23. ZPMC CWI Identified as Mr. Qiu Wen. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U4C.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 066002 perform SMAW welding on; West shaft, Lift 5, intersection diaphragm plate to Skin C and the weld joint is identified as WSD1-TL5-4 B/F-22. ZPMC CWI Identified as Mr. Qiu Wen. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U5B.

3.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 053316 perform FCAW welding on; Lift 13 Component, Bike path and the weld joint is identified as BK 005A -003-069. ZPMC CWI Identified as Mr. Yu Dong Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2131.

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Bay no.10

4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040533 perform FCAW welding on; Lift 13 Component, Bike path and the weld joint is identified as BK 004A6 -030-075. ZPMC CWI Identified as Mr. Qiu Wen. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2131.

5. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 056364 perform SMAW welding on; South shaft, Lift 4, cable tray, Skin C and the weld joint is identified as B22-4-EL. 143.77mtr.-1. ZPMC CWI Identified as Mr. Qiu Wen. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2113.

Blast shop 2

6. This QA inspector, Baskar Govindarajan, performed Pre blast inspection of internal surfaces of North tower, Lift 2. All the areas marked which requires grinding, weld repair, Grinding & MT wherever applicable in all the Skins of Tower from 50.3 to 56 mtr. Elevation. This inspection was carried out along with QA Inspector Mr. Sandeep kumar (B 227). All the marked points shown to ZPMC inspectors. Incident report rose for the same. (Photo attached)

Ultrasonic Testing:

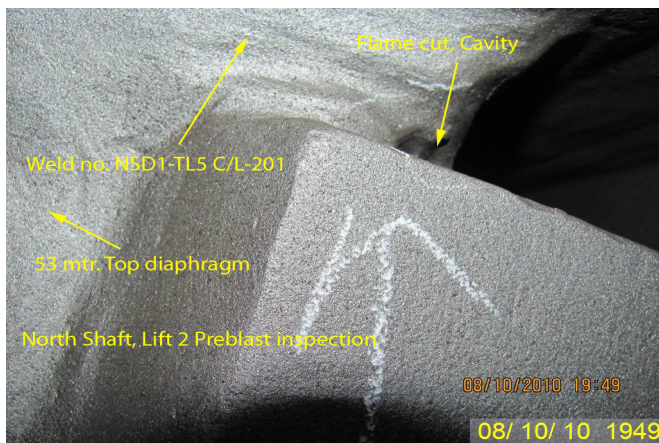
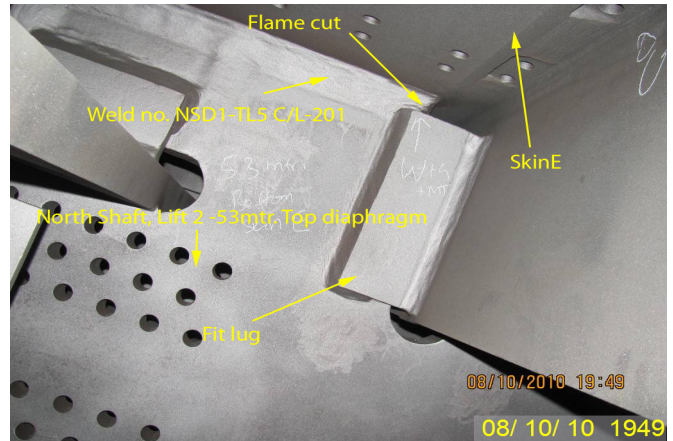
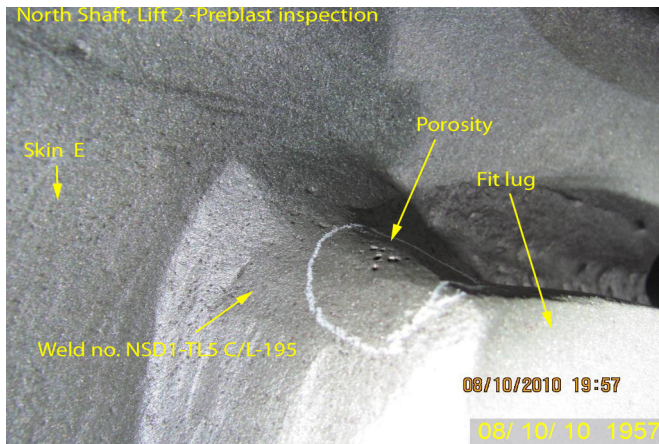
This QA inspector, Baskar Govindarajan, performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted at Tower components by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 UT report for this date. The member is identified as Spare struts at Bay no. 11. (Notification no. 006372) and Interior splice plate (Notification no. 06374). The weld designation reviewed is as follows:

WD1-STSA4-5-131 mtr. -1 – Jt. nos – 7,8,47,48 A/B –Spare strut
ESD1-SPSA5-12 – Jt. nos –1, 2, 3, 4 A/B –interior splice plate

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

This QA Inspector, asked Mr. Steve Hall for the wrapping off welding in diaphragm plates inbetween stiffeners of OBG Lift 13, Side panel plate no. SP3070-001, which was wrapped off. As per Mr. Steve hall, this is an outstanding issue and need solution from Mr. Eric Sang. Since Mr. Eric sang not available today, this will be sorted out tomorrow.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer